

BFK

Work Order ID 111813

111813

Wednesday, January 22, 2014 3:17:57 PM

Item ID: PB67-43001-01

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Blade Fold Assembly

Start Date: 1/22/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/10/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ME

Date: 14-1-22

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-01	Rev C
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0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg and notes on dwg B67-43001 and use 242 threadlock

Blue

A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK Blue batch: 125715

A/R touch up paint with sandflex green

batch: 123883

PC 14.02.19

14-02-19

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

Quality Control

0.00

DAS

27

9-89

14/2/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 111813***111813***

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Item ID: PB67-43001-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Blade Fold Assembly

Start Date: 1/22/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/10/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MCS 14-02-21
MCS 14-02-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 111813

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 1/22/2014

Required Date: 2/10/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
 IPP Rev:B 08-12-04 up date part list DD Verified by:ec
 EC verified by:DD
 IPP RevC 10.09.24 per RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	214.0000	8	16	32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST382		214							
				124060		14							
				M127995		200							
30345T22 8" LANYARD		Purchased	No			100	Each	28.0000	2	4	32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST379		28							
				m127014		8							
				m127979		20							
30345T24 LANYARDS		Purchased	No			100	Each	61.0000	2	4	32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST379		1							
				120208		1							
				ST380		60							
				M127979		60							
AN4-10A Bolt		Purchased	No			100	Each	125.0000	2	4	32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		125							
				M127070		50							
				M127815		75							

M/27598

M/27014

120208 1x
M/27014 3x

M/27070

14/01/23 (2)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 111813

Parent Item: PB67-43001-01

Start Date: 1/22/2014

Required Date: 2/10/2014

Parent Item Name: Fwd Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

AN4-13A	Purchased	No	100	Each	1,506.0000	2	4	DAS 32 9-89
Bolt								

Location	Loc Qty	Loc Code
FG	20	
122808	20	
GA	17	
m125709	17	
ST356	12	
m126193	12	
ST515	1457	
m126193	407	
m127432	50	
m127817	1000	

1/26/93

AN4-15A	Purchased	No	100	Each	506.0000	4	8	DAS 32 9-89
Bolt								

Location	Loc Qty	Loc Code
GA	100	
120449	100	
st357	406	
m127817	406	

1/27/87

AN6-11A	Purchased	No	100	Each	52.0000	2	4	DAS 32 9-89
BOLT								

Location	Loc Qty	Loc Code
ST339	52	
114437	27	
M127993	25	

114437

AN6-20A	Purchased	No	100	Each	63.0000	2	4	DAS 32 9-89
BOLT								

Location	Loc Qty	Loc Code
ST340	63	
123525	2	
123900	1	
M126105	30	
M127044	30	

123525 2p
123900 1p
1/26/05 1p

181/01/23
(2)

Wednesday, January 22, 2014 3:17:55 PM

Shop Packet Print

Page 2

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Work Order ID: 111813

Parent Item: PB67-43001-01

Start Date: 1/22/2014

Required Date: 2/10/2014

Parent Item Name: Fwd Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

AN8-13A Bolt	Purchased	No	100	Each	51.0000	2	4	DAS 32 9-89
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST341	51				
			123482	26		123482		
			M127993	25				
BSP43 RIVET	Purchased	No	100	Each	78.0000	4	8	DAS 32 9-89
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST282	78				
			M127380	78		M127380		
CR3213-4-05 RIVET	Purchased	No	100	Each	522.0000	2	4	DAS 32 9-89
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST328	422				
			123301	222		123301		
			m127376	200				
			ST553	100				
			m127255	100				
D3445-041 Belt Assembly	Manufactured	No	100	Each	11.0000	1	2	DAS 32 9-89
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			Mezz2	11				
			108356	10		108356		
			92251	1		92251		
D3447-3 Square Spacer	Manufactured	No	100	Each	7.0000	2	4	DAS 32 9-89
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			Mezz2	7				
			103840	7		103840		

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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 111813

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 1/22/2014

Required Date: 2/10/2014

Start Qty: 2.00

Required Qty: 2.00

D3447-7	Manufactured	No	100	Each	1.0000	2	4	109508 34	DAS 32 9-89
Clevis									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			Mezz2		1				
			103842		1			103842	
D3447-9	Manufactured	No	100	Each	2.0000	2	4	110604	DAS 32 9-89
Swing Arm									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			Mezz2		2				
			103843		2			103843 2P	
D3451-041	Manufactured	No	100	Each	1.0000	1	2	111742	DAS 32 9-89
Handle And Lock-Down Assembly									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			Mezz2		1				
			104490		1				
D3451-047	Manufactured	No	100	Each	1.0000	1	2	111747	DAS 32 9-89
Handle And Lock-Down Assembly									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			Mezz2		1				
			104630		1				
D3922-1	Manufactured	No	100	Each	13.0000	2	4	66852	DAS 32 9-89
Clip									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			ST072		13				
			66852		13			66852	
MS17984-C408	Purchased	No	100	Each	23.0000	2	4	1126872	DAS 32 9-89 14/01/23 (2)
PIN, QUICK RELEASE									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			ST332		23				
			m126872		13				
			m127376		10				

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 5

Work Order ID: 111813

Parent Item: PB67-43001-01

Start Date: 1/22/2014

Required Date: 2/10/2014

Parent Item Name: Fwd Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

MS17984-C418
PIN, QUICK RELEASE

Purchased No

100 Each 54.0000

2 4

DAS
32
9.89

Location Loc Qty Loc Code

FG 1
123482 1
ST332 53
m126872 3
m127255 10
m127993 40

m126872 14
m127255 30

MS1042L3
Nut

Purchased No

100 Each 5,272.0000

2 4

DAS
32
9.89

Location Loc Qty Loc Code

ST506 962
123900 962
ST509 4310
M127304 1000
M127410 3000
M127831 310

m127831

MS21042L4
Locknut

Purchased No

100 Each 4,331.0000

8 16

DAS
32
9.89

Location Loc Qty Loc Code

GA 68
m126333 68
ST509 4000
m127255 2000
m127813 2000
ST518 263
m127376 263

m127376

14/01/23 (2)

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 6

Work Order ID: 111813

Parent Item: PB67-43001-01

Start Date: 1/22/2014

Required Date: 2/10/2014

Parent Item Name: Fwd Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

MS21042L6	Purchased	No	100	Each	434.0000	4	8	DAS 32 9-89
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST314	434	
120308	4	
m127304	80	
m127831	100	
m127904	250	

120308 4x
m127304 4x

MS27039-1-04	Purchased	No	100	Each	200.0000	2	4	DAS 32 9-89
Screw								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST305	200	
124555	200	

124555

MS27039-1-21	Purchased	No	100	Each	646.0000	2	4	DAS 32 9-89
Screw								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST506	646	
124326	146	
m126319	100	
m127904	400	

124326

MS51859-6	Purchased	No	100	Each	137.0000	4	8	DAS 32 9-89
WASHER								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST290	137	
123482	87	
m126474	50	

123482

MS51859-7	Purchased	No		Each	123.0000	4	8	DAS 32 9-89
Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST290	123	
123482	18	
123525	5	
M127993	100	

123482 3x
123525 5x

12/01/23

②

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 111813

Parent Item: PB67-43001-01

Start Date: 1/22/2014

Required Date: 2/10/2014

Parent Item Name: Fwd Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

MS51859-8	Purchased	No	100	Each	230.0000	8	16	<u>✓</u>	DAS 32 9-89
Washer									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST290	230	
m127255	30	
m127993	200	

m127255

NAS1149DN632J	Purchased	No	100	Each	306.0000	6	12	<u>✓</u>	DAS 32 9-89
Washer									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST293	306	
M126084	206	
M127255	100	

m126084

NAS1149F0316P	Purchased	No	100	Each	134.0000	4	8	<u>✓</u>	DAS 32 9-89
WASHER									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST295	134	
113237	34	
113644	100	

111327

NAS1149F0432P	Purchased	No	100	Each	1,286.0000	16	32	<u>✓</u>	DAS 32 9-89
WASHER									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST295	778	
M121350	28	
M127813	750	
ST510a	508	
M126221	508	

m126221

NAS1149F0632P	Purchased	No	100	Each	269.0000	8	16	<u>✓</u>	DAS 32 9-89
WASHER									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST295	269	
18057	269	

m18057

m101/23 (2)

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 111813

Parent Item: PB67-43001-01

Start Date: 1/22/2014

Required Date: 2/10/2014

Parent Item Name: Fwd Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0832P

Purchased

No

100

Each

222.0000

2

4

DAS
32
9-89

WASHER

Location

Loc Qty

Loc Code

ST295

222

18057

222

18057

NAS43DD3-68

Purchased

No

100

Each

65.0000

2

4

DAS
32
9-89

Spacer

Location

Loc Qty

Loc Code

ST275

65

124330

65

124330

PB67-43001-07

Manufactured

No

100

Each

0.0000

1

2

Fwd Blade Fold Assembly Weldment

PB67-43001-11

Manufactured

No

100

Each

0.0000

1

2

Fwd Adjustable Blade Support Assembly

PB67-43001-15

Manufactured

No

100

Each

1.0000

1

2

Fwd Adjustable Blade Support Assembly

Location

Loc Qty

Loc Code

Mezz2

1

104661

1

104661

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

2

Upper Blade Support And Cover Assembly

PB67-43001-23

Manufactured

No

100

Each

0.0000

1

2

Lower Blade Support And Cover Assembly

PB67-43001-261

Manufactured

No

100

Each

0.0000

2

4

Lever Arm

PB67-43001-265

Manufactured

No

100

Each

57.0000

4

8

DAS
32
9-89

Deltin Bushing

Location

Loc Qty

Loc Code

Mezz2

57

111103

20

99967

37

99967

14/2/5 (2)

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Work Order ID: 111813

Parent Item: PB67-43001-01

Start Date: 1/22/2014

Required Date: 2/10/2014

Parent Item Name: Fwd Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-299	Manufactured	No	100	Each	31.0000	2	4	9-89	DAS 32 9-89
Bushing									

Location

Loc Qty

Loc Code

Mezz2

31

99957

31

PB67-43001-45	Manufactured	No	100	Each	0.0000	1	2	9-89	DAS 32 9-89
Longitudinal Support									

PB67-43001-51	Manufactured	No	100	Each	0.0000	1	2	9-89	DAS 32 9-89
Long T-Handle Assembly									

17/2/10 (2)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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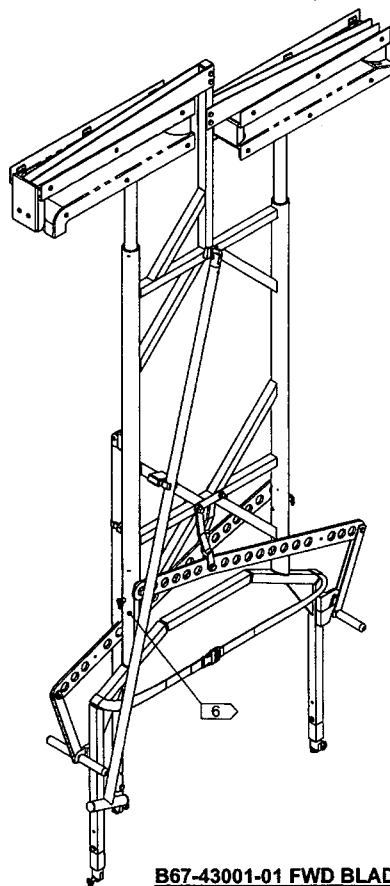
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY. -01	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG T-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELTRIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN6-20A	BOLT
25	2	AN8-13A	BOLT
26	4	BSP43	RIVET
27	2	CR3213-4-05	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS51859-6	NYLON WASHER
37	4	MS51859-7	NYLON WASHER
38	8	MS51859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242XX	LOCTITE 242 THREADLOCKER, BLUE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\phi 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING $1/8"$ DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING).
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOW. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR009-011		VS	10.06.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VS			
CHECKED	VS	DRAWING NO.	REV. C	
MFG. APPR.	VS	B67-43001-01	SHEET 1 OF 2	
APPROVED	VS	TITLE	SCALE	
DE APPR.	VS	FWD BLADE FOLD ASSY	NTS	
DATE	10.06.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

mk
11183
14-1-22

RELEASED
2010-09-21
mp

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

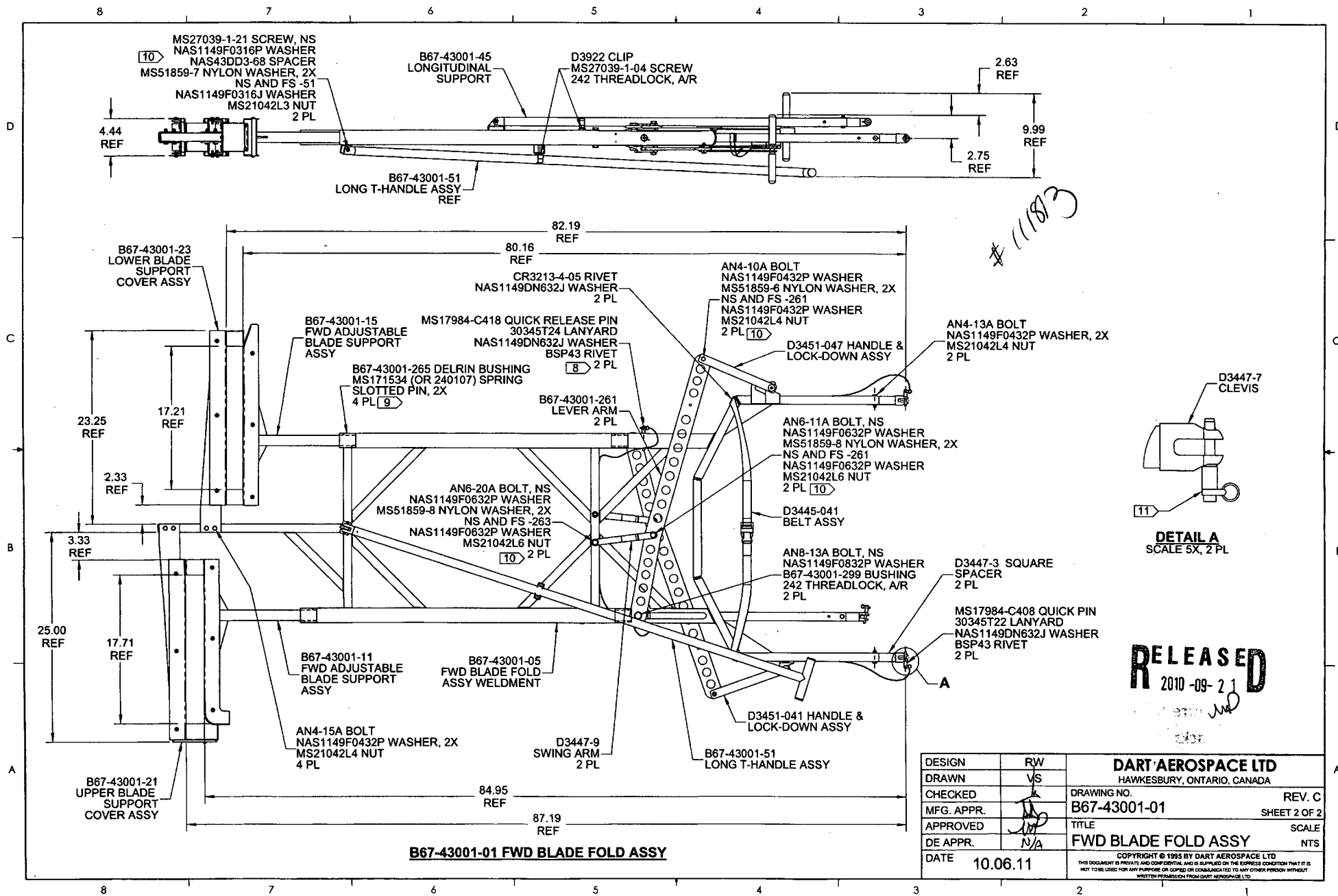
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